

Work Order ID 69594

Thursday, May 12, 2011 3:23:31 PM



Page 1

Item ID: D2858-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 5/12/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan: *AK* Date: 11-05-12

Tooling:

Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2858

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.850

" Note: 1 Blank Makes 3 Parts

*F.K. 11/08/11*8*φ*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA941

FOLIO REV: AADWG REV: C

2-Deburr any rough edges

SL 11-08-22(24)*φ*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SL 11-08-22*24*φ*

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

B.2 11/08/22

24

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

24X0 M-11/08/24

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:45

3200F

M117745 4:15

24X0 M-11/08/24

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Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				24	14	11-8-24	
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>8724</u> Memo	0.00 0.00				24	80	11-08-24	
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/8/25	

CL 11/08/25

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, May 12, 2011 3:23:36 PM

Page 1

Work Order ID: 69594



Parent Item: D2858-2



Parent Item Name: Hinge Bracket

Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP ☐ C ☐ 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			110	f	12.9418	0.163	4.117895			



6061-T6 Bar 1.50 x 1.25



F.K. 11/08/11

Location

Loc Qty

Loc Code

MAT004

12.9418

107461

0.9

110936

12.0418

- 118071

4.118

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69594
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	172	✓		Vern JL-3	
Ø0.400	+0.005/-0.000	400	✓		"	
R0.125	+/-0.010	125	✓		R-G	
0.328	+/-0.010	328	✓		"	
0.820	+/-0.005	820	✓		"	
1.476	+/-0.010	1.476	✓		"	
0.342	+/-0.010	342	✓		"	
0.875	+/-0.010	875	✓		"	
1.56	+/-0.030	1.560	✓		"	
0.147	+/-0.010	150	✓		"	
0.717	+/-0.010	723	✓		H-G	
0.697	+/-0.010	697	✓		"	
0.229	+/-0.010	229	✓		"	
R0.125	+/-0.010	125	✓		R-G	
R0.063	+/-0.010	063	✓		R-G	
0.063	+/-0.010	060	✓		"	
0.126	+/-0.010	122	✓		"	
0.630	+/-0.010	629	✓		"	
R0.354	+/-0.010	354	✓			
0.965	+/-0.010	965	✓		✓	
Ø0.166	+0.005/-0.000	166	✓		✓	

Measured by:	<i>[Signature]</i>	Audited by:	B.A	Prototype Approval:	N/A
Date:	11-08-22	Date:	11/08/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

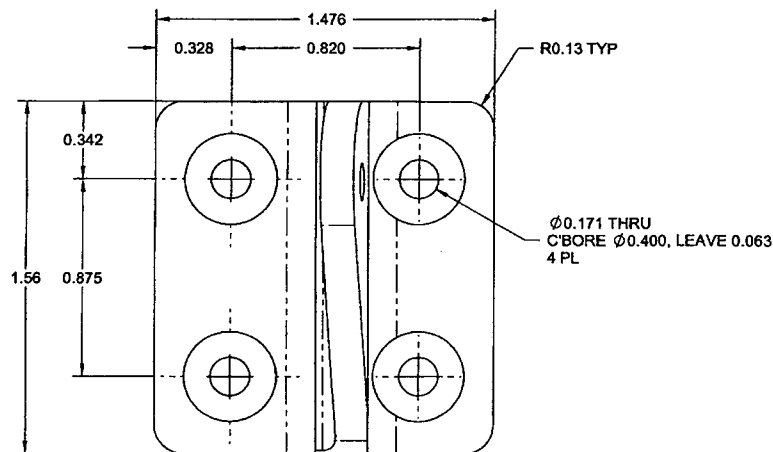
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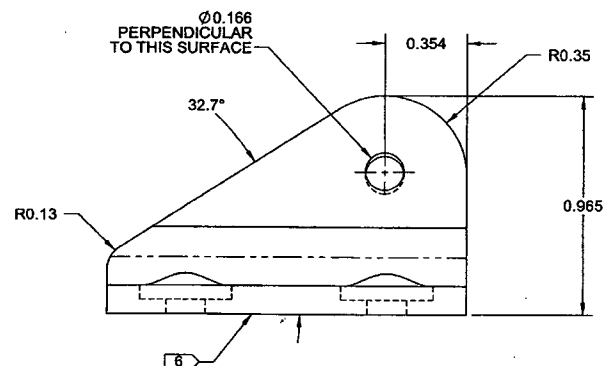
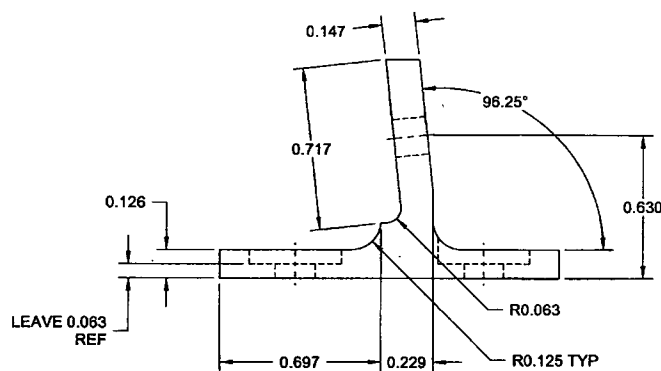
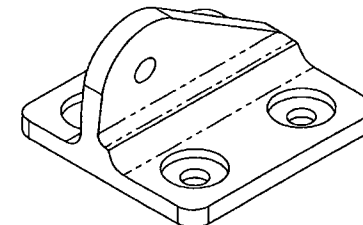
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69594
PH-05-12



RELEASED
2010-11-26

D2858-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

C	REDRAW TO CURRENT STD, REMOVE ENGRAVED P/N, IDENT. NOW W/ MARKER (A8-1, A8-2), REF PAR 10-040	CP	10.10.12
B	0.717 WAS 0.667, 1.56 WAS 1.559	KE	99.02.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	dp		
CHECKED	dp	DRAWING NO.	REV. C
MFG. APPR.	dp	D2858	SHEET 1 OF 2
APPROVED	dp	TITLE	SCALE
DE APPR.	dp	HINGE BRACKET	NTS
DATE	10.10.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

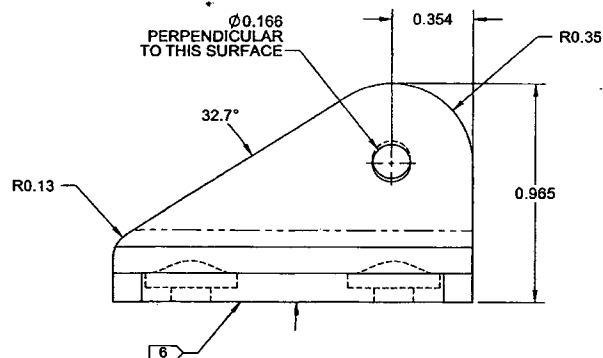
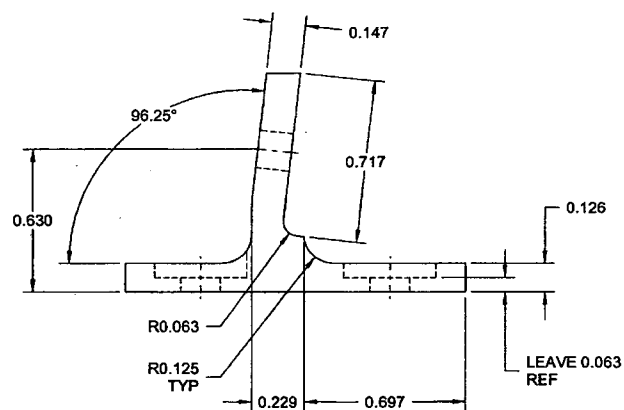
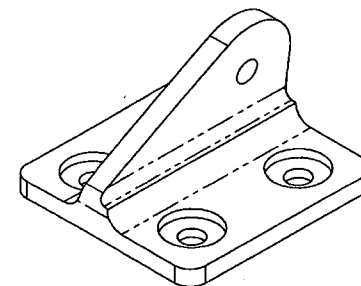
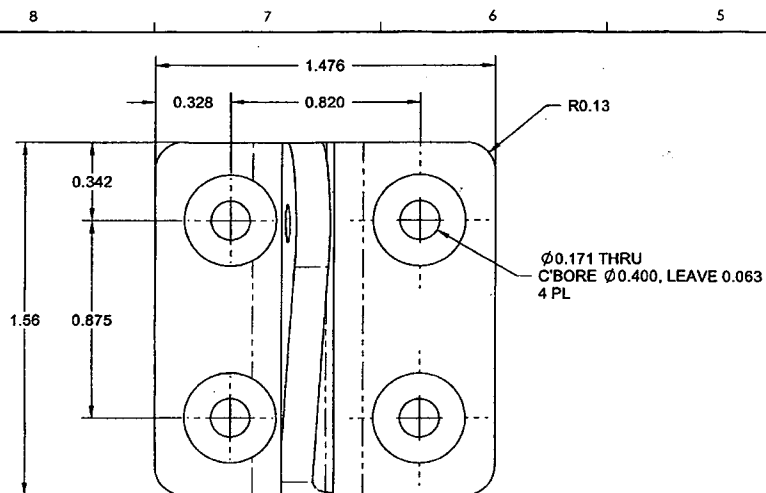
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W069594

RELEASED
2010-11-26

D2858-2 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 7) WEIGHT: 0.04 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2858	REV. C
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE HINGE BRACKET	SCALE
DE APPR.		NTS	
DATE	10.10.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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